

Date: Thursday, 23/10/2008 10:54:08 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number :	42887	Part Number :	D29332UP
Estimate Number :	12931	Drawing Number :	D2933 REV C
P.O. Number :		Project Number :	N/A
This Issue :	23/10/2008	Drawing Revision :	C
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	15/11/2008
Previous Run :	41726	Qty:	10 42887
Written By :		Um:	Each
Checked & Approved By :	JL 08.10.23		
Comment :	Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

D6101001

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B 34872 DJP 08/10/31



2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

JL 08/11/02

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

JL 08/11/07

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JL 08/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:08 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 42887

Part Number: D29332UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 08/11/07

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF

08/11/10

(10X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SD

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

8/11/10

(10X)

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42887
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.111	.113	.115	.118		
B	0.100	0.140		.107	.113	.107	.118		
C	0.100	0.140		.125	.123	.122	.118		
D	0.210	0.230		.211	.221	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.116	.120	.118	.118		
O	0.540	0.560		.549	.548	.547	.551		
P	0.490	0.510		.502	.502	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.255	.261	.261	.261		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.133	1.140	1.136	1.134		
Y	1.565	1.585	DT8695 A/B	1.571	1.576	1.574	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	08/11/02

Audited by:	BB
Date:	08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.120	.120	.119		
B	0.100	0.140		.120	.118	.120	.119		
C	0.100	0.140		.119	.120	.119	.118		
D	0.210	0.230		.221	.222	.221	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.119	.120	.118		
O	0.540	0.560		.550	.552	.552	.550		
P	0.490	0.510		.501	.502	.501	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.261	.262	.263	.264		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.136	1.136	1.136	1.134		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.574	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
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Inspection Dwg: D2933 Rev. C	Page 1 of 1

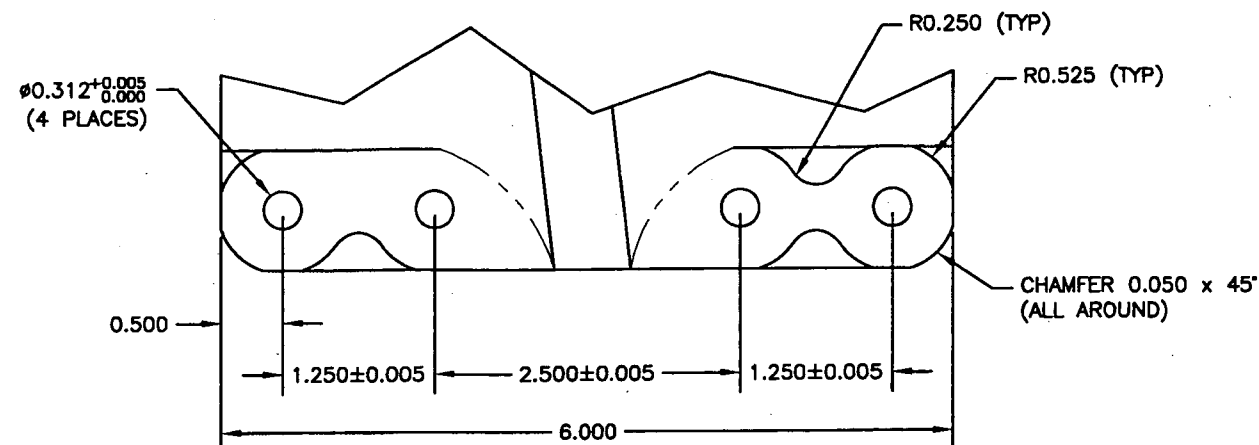
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Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	.120				
B	0.100	0.140		.119	.119				
C	0.100	0.140		.119	.120				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.118	.119				
O	0.540	0.560		.552	.550				
P	0.490	0.510		.502	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.261	.262				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.136	1.134				
Y	1.565	1.585	DT8695 A/B	1.575	1.574				
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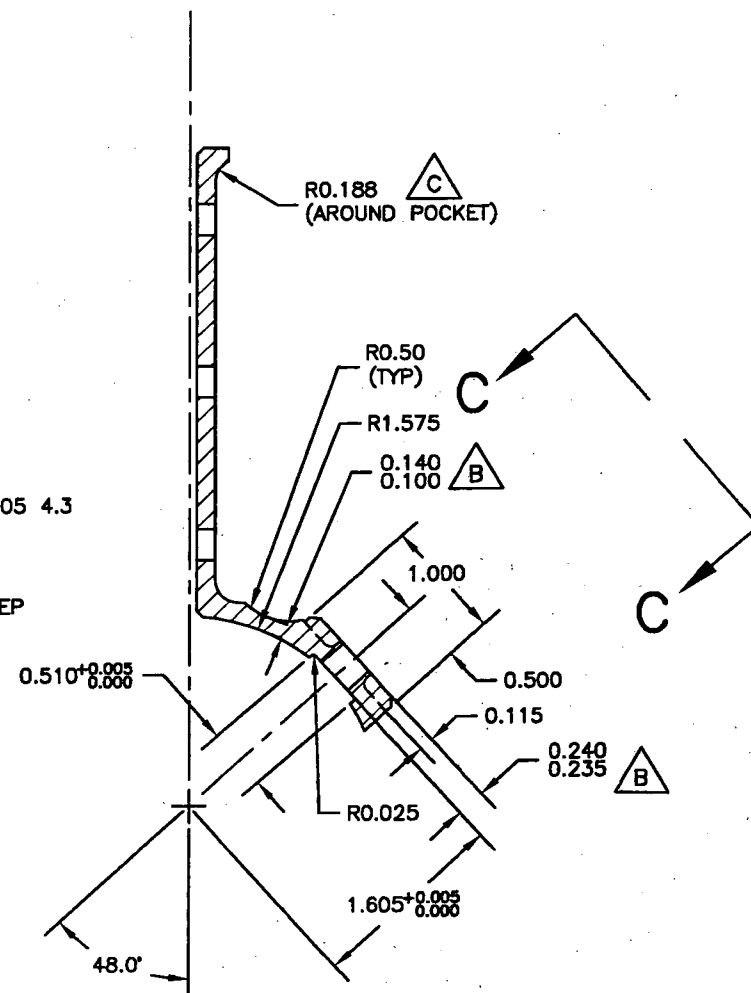


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

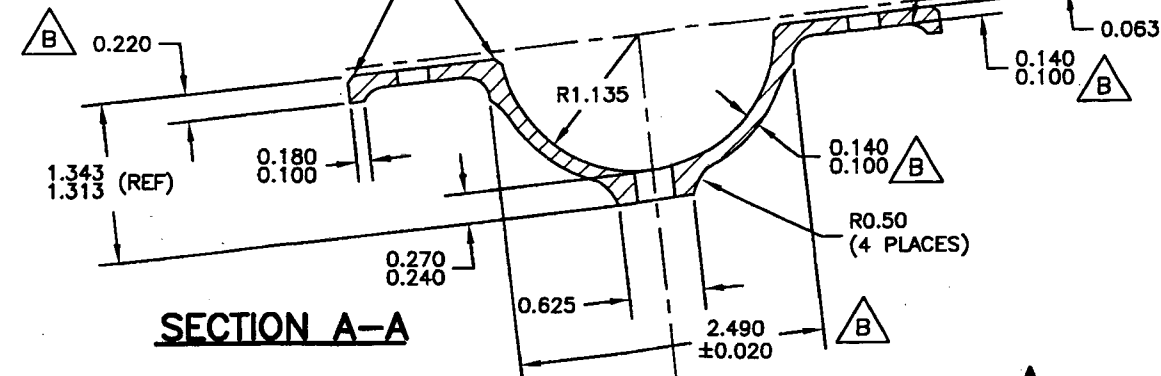
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

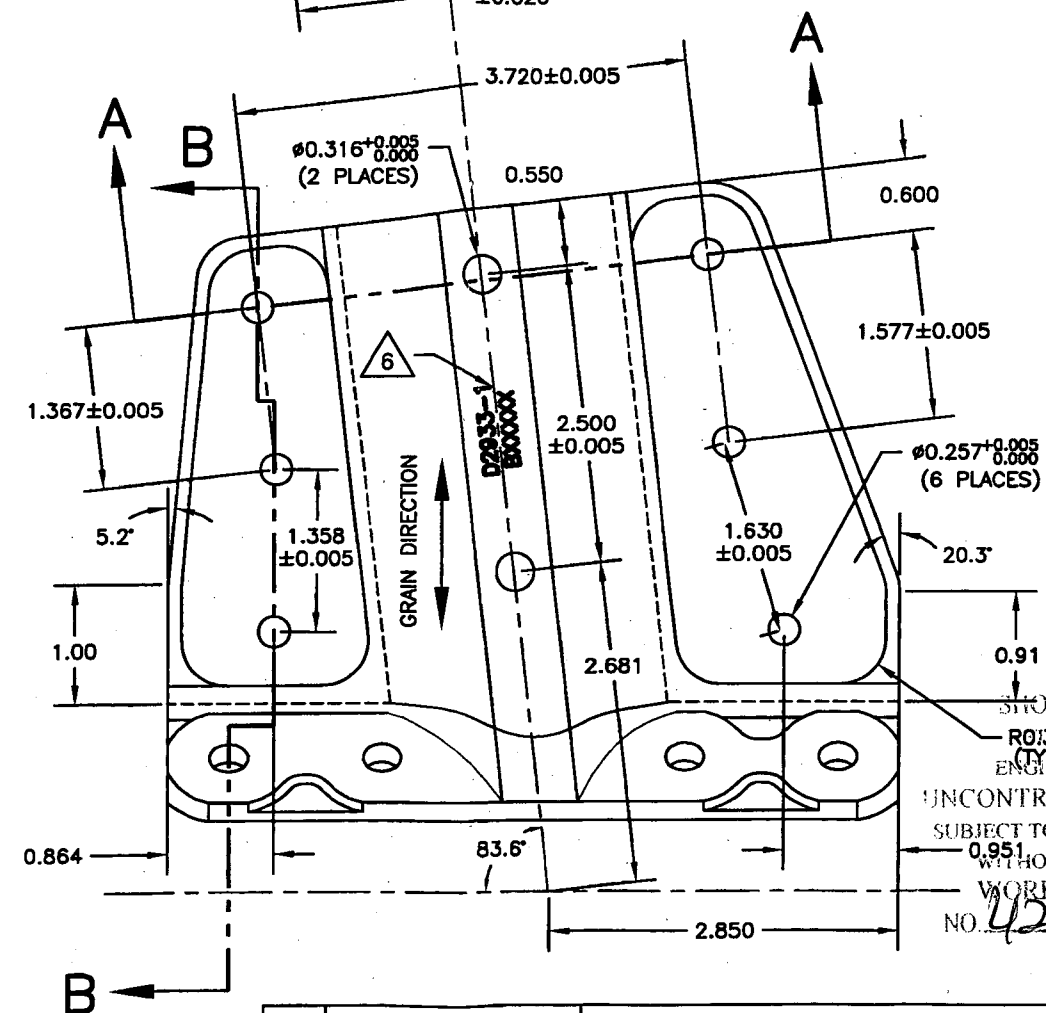


SECTION B-B

CHAMFER 0.050 x 45° AROUND
THIS SURFACE (TYP 2 PLACES)



SECTION A-A



STOP COPY
R0.188 (TYP)
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42857

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.

RELEASED

07.02.12

